

Work Order ID 82982

82982

Page 1

Thursday, April 12, 2012 10:17:08 AM

Item ID: D4034-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib
 Start Date: 4/12/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-04-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|--|------|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4034 | B | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1- Cut tube as per dwg D4034 2- Drill and chamfer holes as per dwg use DT9715 | | | | | | | | |
| 110 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *120* | <i>Booklet call</i> | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

[Handwritten: 10] *[Handwritten: 12/04/25]*

[Handwritten: 10x] *[Handwritten: 12.05.01]*

[Handwritten: 10x] *[Handwritten: 12.05.01]*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82982***82982***

Page 2

Thursday, April 12, 2012 10:17:08 AM

Item ID: D4034-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 4/12/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/4/30
R12-04-30

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 12, 2012 10:17:11 AM

Page 1

Work Order ID: 82982

82982

Parent Item: D4034-3

D4034-3

Parent Item Name: Rib

Start Date: 4/12/2012

Required Date: 4/20/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC IPP Rev:D 11.01.19 AS PER DWG
REV.B DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304TS0.750W.049

Purchased

No

100

f

519.6045

1.4375

15.13158

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

6/12-04-25
DL/12-04-25

Location

Loc Qty

Loc Code

MAT018

248.3105959

117775

93.6739

118472

47.1990839

118880

0.2736

119147

76.4906

119643

17.1154

120494

13.5580119

MAT034

248.367327

117337

1.8507

121087

246.516627

WA035

22.92654

118184

22.92654

4.604727

10.527273

Dart Aerospace Ltd

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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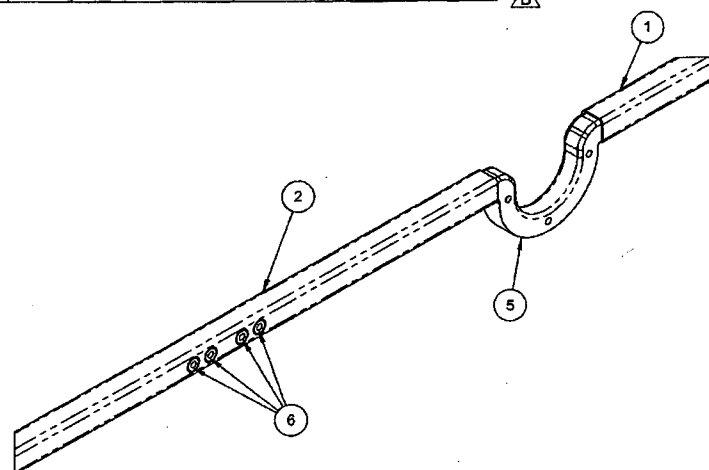
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

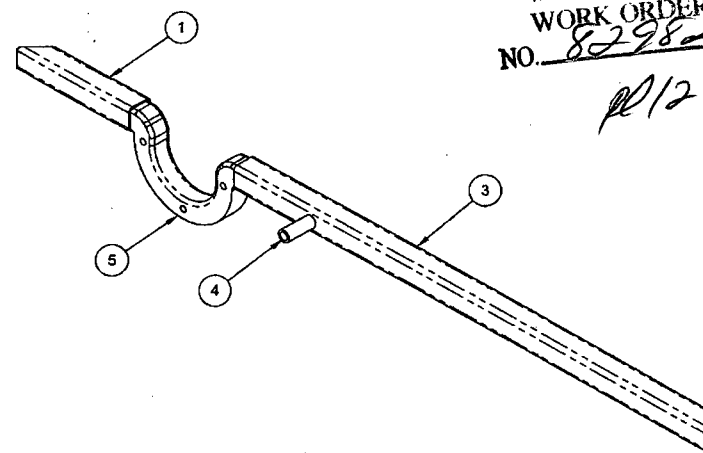
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|--------------------|
| | X | | D4034-041 | AFT UPPER RIB ASSY |
| | | X | D4034-043 | FWD UPPER RIB ASSY |
| 1 | 1 | 1 | D4034-1 | RIB |
| 2 | 1 | | D4034-3 | RIB |
| 3 | | 1 | D4034-5 | RIB |
| 4 | | 1 | D2327-3 | SPACER BUSHING |
| 5 | 1 | 1 | D4021-7 | HOOP |
| 6 | 4 | | D4021-9 | BUSHING |



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82982

R12 04-12

RELEASED
R 2011-01-18
MP

| | | | |
|------------|---------------------------------------|--|--------------|
| B | ADDITIONAL HOLES ADDED ON D4034-3 RIB | SC | 10.12.20 |
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 TITLE UPPER RIB ASSY, BASKET BASE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DRAWN | SC | | |
| CHECKED | R | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | REV. B | SHEET 1 OF 4 |
| DATE | 10.12.20 | SCALE | NTS |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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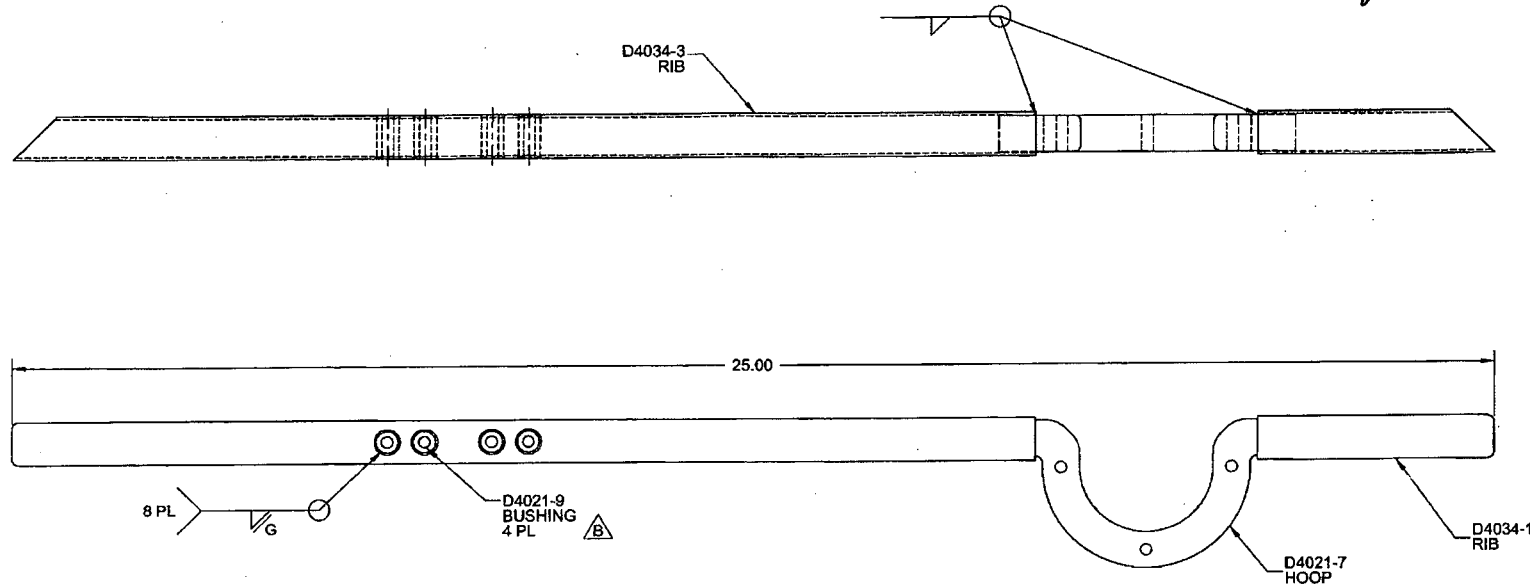
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

52982



D4034-041 AFT UPPER RIB ASSY

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|-------------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | B | DRAWING NO. | REV. B |
| MFG. APPR. | [Signature] | D4034 | SHEET 2 OF 4 |
| APPROVED | [Signature] | TITLE | SCALE |
| DE APPR. | [Signature] | UPPER RIB ASSY, BASKET BASE | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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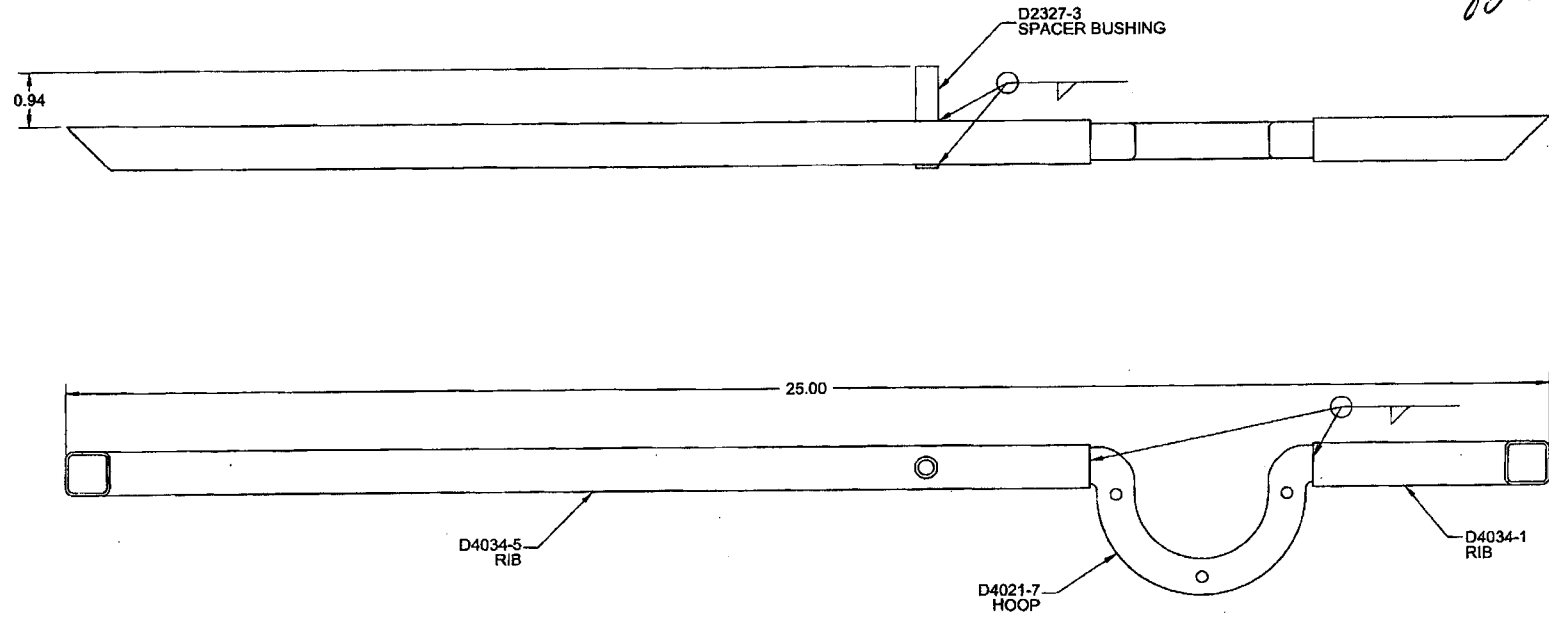
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NOTE: Date & initial all entries




82982



D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

| | | | |
|--|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. 3 |
| MFG. APPR. |  | D4034 | SHEET 3 OF 4 |
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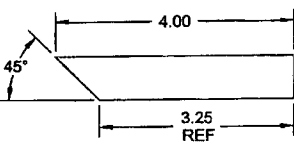
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

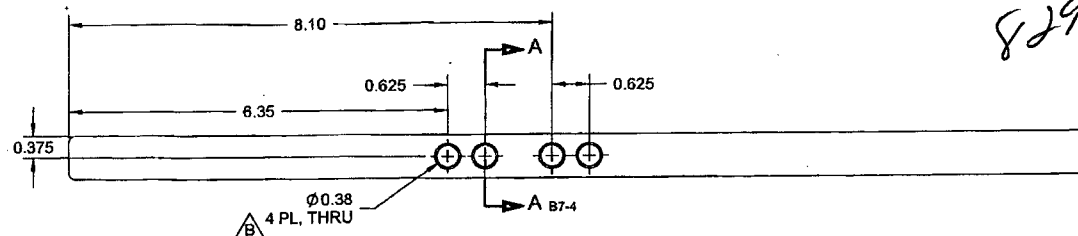


D4034-1 RIB

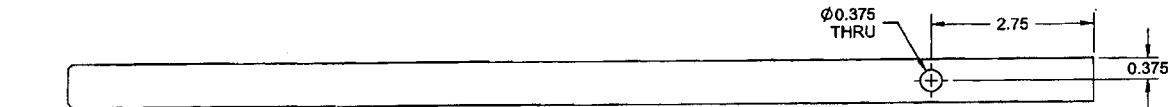
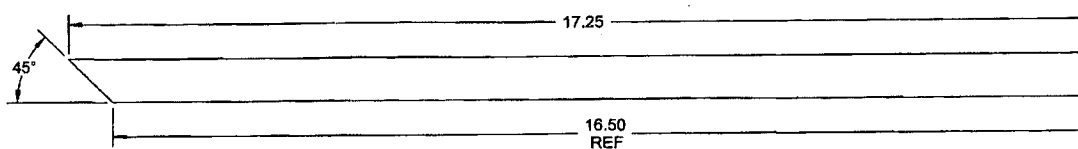
BREAK EDGE
0.030 X 45°
TYP



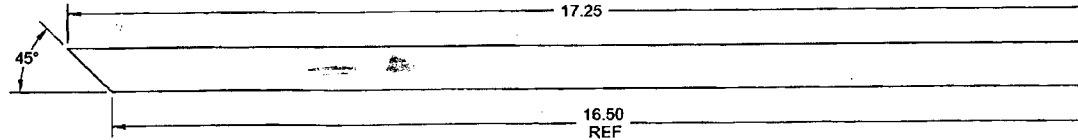
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

| | | | |
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| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4034 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
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RELEASED
2011-01-10

82982

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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